

Work Order ID 59444

Friday, June 04, 2010 11:24:02 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Item Name: 206 (24") Bearpaw

Stop



Start Date: 6/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10-6-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

*B10-6-7**(8)*

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

and 10/06/10
1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr*8**8*

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*and 10/06/10**8**8*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59444

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Page 2

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Start Date: 6/4/2010 Start Qty: 8.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>MT</i> <i>10/06/11</i>		<i>8</i>	<i>8</i>		
151 Packaging Packaging	Identify as per dwg & Stock Location: <i>PPP</i> Memo <i>58477</i>	0.00 0.00							<i>10/06/14</i> <i>8</i>
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>10/06/14</i> <i>MF</i> <i>10-6-14</i>

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Picklist Print

Friday, June 04, 2010 11:24:07 AM

Page 1

Work Order ID: 59444

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	428.7000	3.7	29.6			



UHMW 1" Black



18 10-6-7

Location

Loc Qty

Loc Code

MAT

428.7

112186

20.7

113903

88

114624

320

114 624



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DART AEROSPACE LTD		Work Order:	594114
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.056x45°	—			
B	5.500	+/-0.030	5.506	—			
C	0.200	+/-0.030	.204	—			
D	0.25 x 45°	+/-0.030	.275x45°	—			
E	R0.250	+/-0.030	R.250	—			
F	0.250	+/-0.010	.241	—			
G	0.625	+/-0.030	.617	—			
H	0.375	+/-0.010	.375	—			
I	0.950	+0.030/0.010	.950	—			
J	19.000	+/-0.030	19.000	—			
K	3.14	+/-0.030	3.140	—			
L	3.28	+/-0.030	3.280	—			
M	Ø0.260	+0.005/-0.000	Ø.260	—			
N	Ø0.93	+/-0.030	Ø.928	—			
O	0.30	+0.030/-0.000	.306	—			
P	23.750	+/-0.030	23.750	—			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	—			
S	2.000	+/-0.030	2.000	—			
T	9.000	+/-0.010	9.000	—			
U	9.000	+/-0.010	9.000	—			
V	0.375	+/-0.010	.379	—			

Measured by:	<i>[Signature]</i>
Date:	10/06/10

Audited by:	<i>[Signature]</i>
Date:	10/06/10

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

Dart Aerospace Ltd

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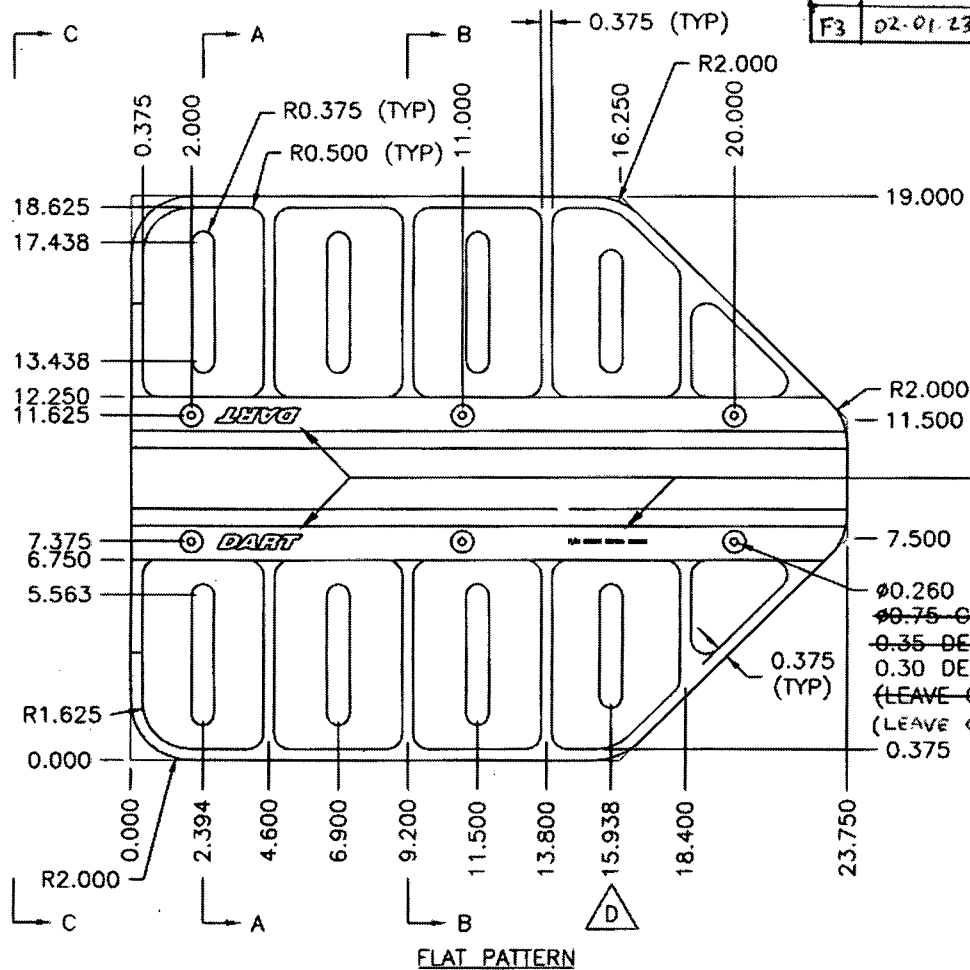
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F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
93.06.17 KE

S.
R.
ENG:
UNCONTROLLED
SUBJECT TO A
WORK ORDER
NO. 59444
p/10-604



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. F
CHECKED KE	APPROVED KE		
DATE 98.05.12	TITLE BEARPAW	DRAWING NO. D2432	SHEET 1 OF 2
A	95.10.31	NEW ISSUE	SCALE 1:6
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

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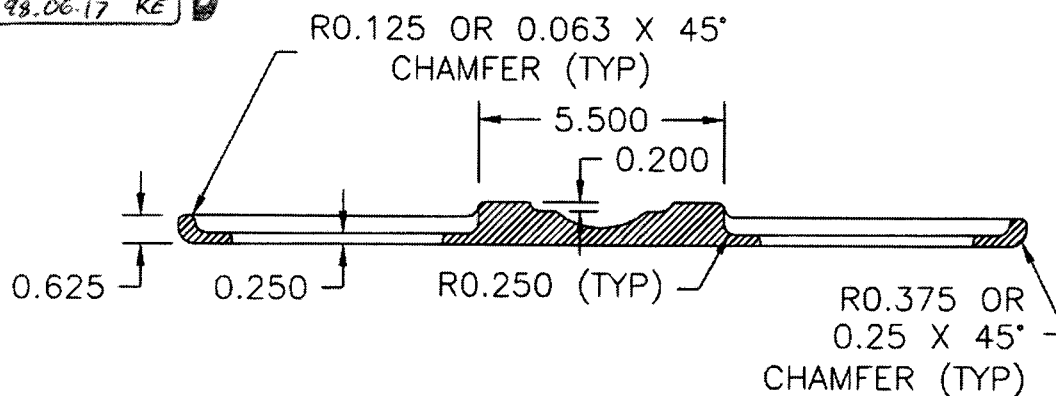
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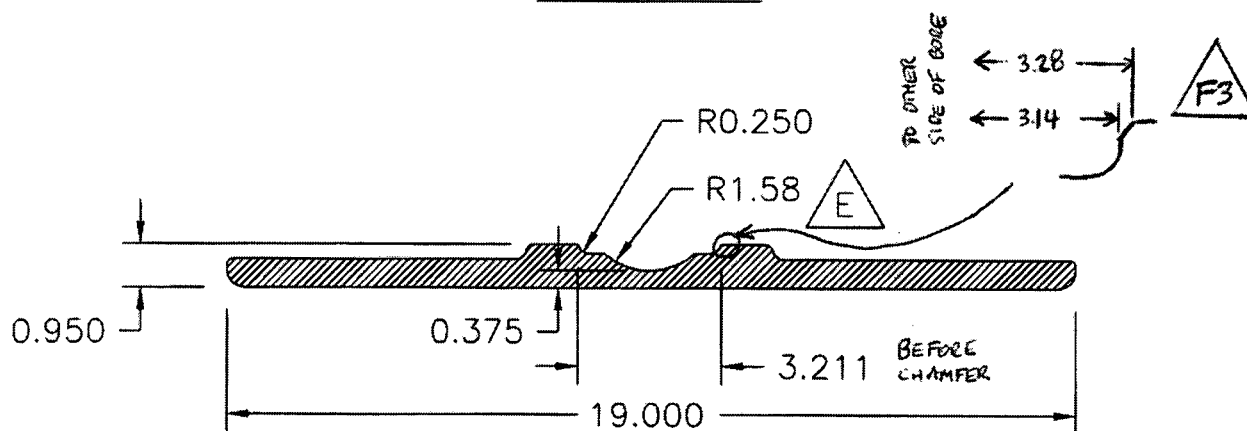


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>mm</i>	APPROVED <i>AS</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

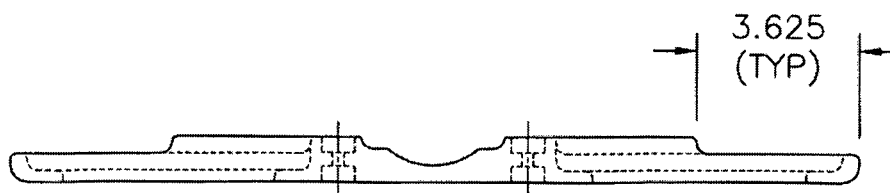
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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